



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5520-1
Job Sheet 179499-A



Part No: D5520-1

Job Qty: 10 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 9/6/18

Job Tracking No:

Due Date: 6/29/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D5520 REV.A IPP REV:A 17.05.12 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC	10 pcs		6/29/18	0.00	0.00	QC8-6		
130	Brake NC	10 pcs		6/29/18	0.00	0.67	Brake NC 1		
140	QC	10 pcs		6/29/18	0.00	0.00	QC5		
150	HandFinish	10 pcs		6/29/18	0.00	0.50	HandFinish1		
160	QC	10 pcs		6/29/18	0.00	0.00	QC7-5		
170	SprayPaint	10 pcs		6/29/18	0.00	1.67	Spray Paint		
180	QC	10 pcs		6/29/18	0.00	0.00	QC3		
190	Packaging	10 pcs		6/29/18	0.00	0.00	Packaging3-2		
200	QC21-SA	10 Ea		6/29/18	0.00	0.00	QC21		

Part Op 120 - QC8- Inspect parts - second check

Descriptions: 130 - FORM TO CORRECT RAD AS PER DWG "USE THE INSIDE EXTRUSION D2962 FOR FIT TEST"

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Prime as per Dart QSI 005 4.2 Primer Batch: 138976

180 - QC3- Inspect Part Finish

190 - Identify as per dwg & Stock Location: 157001

200 - QC21- Final Inspection - Work Order Release

Job BOM



Container No: S108428



Part: D5520-1

Job No: 179499-A

Serial No/Batch: S082767

Revision: A

Inspector:

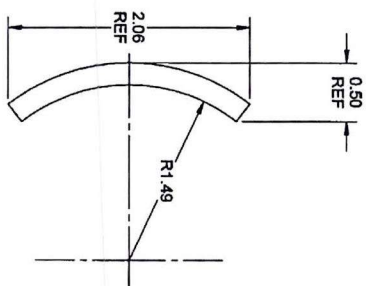
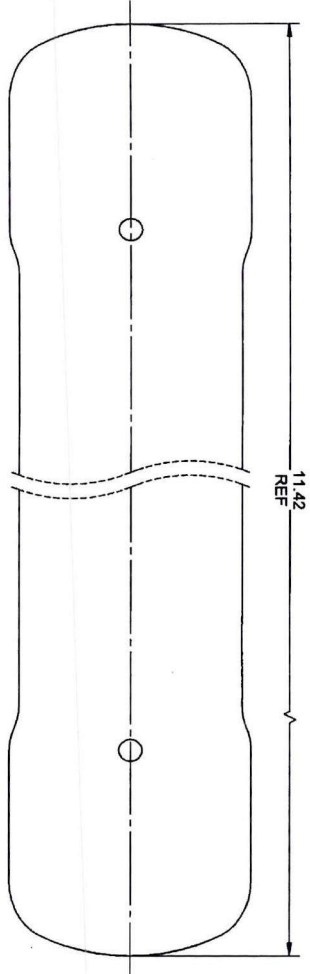
Exp Date:

Instructions: Various STC's

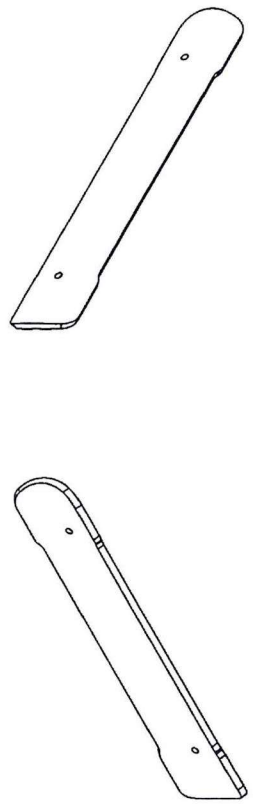
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/14/19

Plex 1/14/19 11:05 AM dart.boucher.sylvie



D5520-1 DOUBLER
(BEND DETAIL)

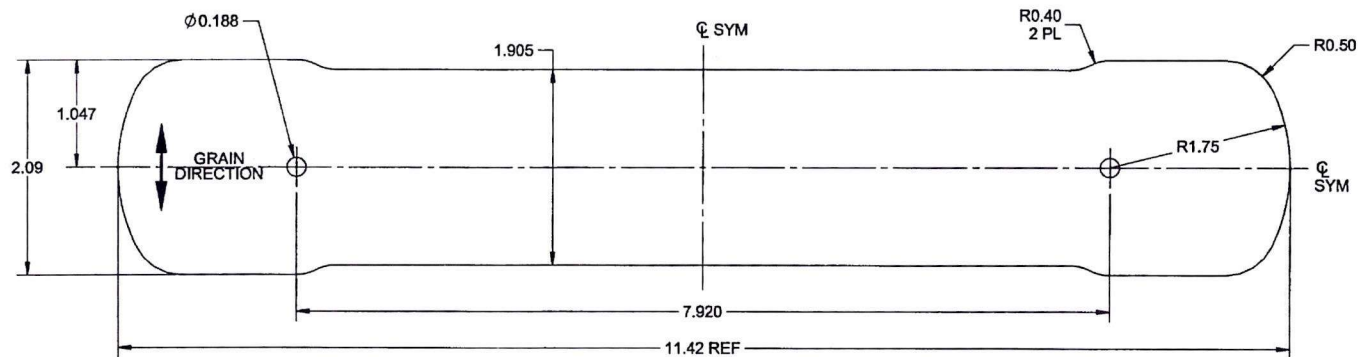


- NOTES:**
- 1) MATERIAL: MAKE FROM D5520-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.40 lbs

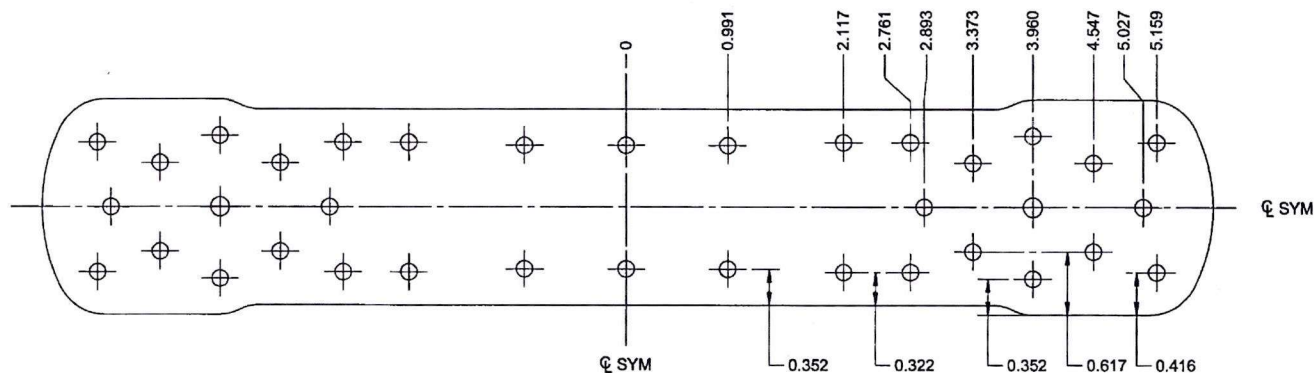
RELEASED
R 2017-08-11
17-547

APPROVED

REV.	DESCRIPTION	ML	DATE
A	NEW ISSUE (NCR17-5303)	ML	17.03.09
DESIGN	ML		
DRAWN	AJS		
CHECKED	ML		
MFG. APPR.	DP		
APPROVED	WM		
DE APPR.	DS-#		
DATE	17.03.09		
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D5520-1F DOUBLER
(FLAT PATTERN)



D5520-1F DOUBLER

+ REPRESENTS THE LOCATION OF RIVET HOLES
TO BE DRILLED ON INSTALLATION
(HOLES SHOWN AS REFERENCE ONLY)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR/SHEET, 0.188 THICK
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221 OR QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6B0.188 OR M6061T6S0.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs
- 8) DRILL HOLES USING DT10309

RELEASED
2017-08-11

APPROVED

DESIGN	ML	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	DP	D5520	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	17.03.09	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5520-1

Job Sheet 179499



Part No: D5520-1

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/19/18

Job Tracking No:

Due Date: 6/29/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG D5520 REV.A IPP REV:A 17.05.12 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Waterjet		SC 18/06/20
100	Waterjet	20 pcs	6/29/18	6/29/18	0.00	2.50	Waterjet1		SC 18/06/20
110	QC	20 pcs	6/29/18	6/29/18	0.00	0.00	QC2 Waterjet-4		SC 18/06/20
120	QC	20 pcs	6/29/18	6/29/18	0.00	0.00	QC8-6		
130	Brake NC	20 pcs	6/29/18	6/29/18	0.00	1.33	Brake NC 1		
140	QC	20 pcs	6/29/18	6/29/18	0.00	0.00	QC5		
150	HandFinish	20 pcs	6/29/18	6/29/18	0.00	1.00	HandFinish1		
160	QC	20 pcs	6/29/18	6/29/18	0.00	0.00	QC7-5		
170	SprayPaint	20 pcs	6/29/18	6/29/18	0.00	3.33	Spray Paint		
180	QC	20 pcs	6/29/18	6/29/18	0.00	0.00	QC3		
190	Packaging	20 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		
200	QC21-SA	20 Ea	6/29/18	6/29/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg ***VERIFY GRAIN DIRECTION*** Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - FORM TO CORRECT RAD AS PER DWG "USE THE INSIDE EXTRUSION D2962 FOR FIT TEST"

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Prime as per Dart QSI 005 4.2 Primer Batch: _____

180 - QC3- Inspect Part Finish

190 - Identify as per dwg & Stock Location: _____

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.188	6061-T6 .188 Sheet	3.3200 sf (.166 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.188	3	46	0

Part Specifications

Specifications could not be found.

Plex 6/19/18 3:40 PM dart.white.jesse